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## **Developing and testing of a new balance for monitoring lyophilisation in vials**

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This new patented balance has been designed to be installed inside any freeze-dryer to monitor the lyophilization process and to determine in real time the end of the primary drying without interfering with the ongoing lyophilization process.

The balance can be placed in the vacuum chamber of a freeze dryer where it can weigh up to 15 of the vials which are being lyophilized. The weighed vials lay on the tray with all the other lyophilized vials during all the lyophilization process except for few seconds during the actual weighing so that the measurement can be considered representative of the whole batch. This represents a remarkable innovation with respect to other available monitoring approaches, which require either the removal of the vials via an air thigh duct or alter the thermal transfer on the weighed vials.

The balance has a range of 2 kg, a mass resolution of few milligrams and an uncertainty of few tens of milligrams over a wide temperature range ( $-40^{\circ}\text{C}$ ,  $+40^{\circ}\text{C}$ ). The balance is also equipped with auxiliary temperature probes (up to three thin thermocouples in the current version), which can be inserted inside the weighed vials to monitor the temperature within the lyophilized substance during the process. A wireless transmission approach ensures the temperature probes do not affect the weigh measurement and the negligible sensor dimension makes its effect on the lyophilization process almost negligible thus ensuring the thermal measurement is representative of the complete process.

The balance has been tested in a pilot-scale freeze dryer (Lyobeta–Telstar), equipped with other control thermocouples, Pirani and Baratron pressure sensors and a mass spectrometer for the measurement of the composition of the chamber atmosphere.

The experimental data have been obtained from various cycles carried out with batches composed of 50 to 700 vials, filled with a 10% w/w sucrose solution. The tests highlighted a good agreement between the trends of the measured mass and temperature. In particular, in correspondence of the increase of the product temperature at the end of primary-drying, the balance starts measuring an almost constant value of the weighed mass. This suggests that the final point of the sublimation phase could be detected just using the on-line measurement of the mass measured by the developed balance.

A very good agreement was also observed with the estimation of the sublimation front carried out using our Dynamic Parameter Estimator method, and advanced tool derived from classic manometric temperature measurement.